



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

1/0W
0.25
MUST SHIP NO LATER THAN DEC 19

D4935-1
Job Sheet 168432-A



Part No: D4935-1

Job Qty: 20 ea

Part Name: Mounting Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/14/17

Job Tracking No:

Due Date: 12/18/17

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 13.10.02 NEW ISSE DD VERF:JLM IPP REV:B 14.06.18 AS PER DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	12/16/17	12/16/17	0.00	0.00	Start Up Waterjet		SC
100	Waterjet	20 pcs	12/16/17	12/16/17	0.00	0.73	Waterjet1		SC
110	QC	20 pcs	12/16/17	12/16/17	0.00	0.00	QC2		SC DAS
120	QC	20 pcs	12/16/17	12/16/17	0.00	0.00	QC8		38
130	Brake NC	20 pcs	12/16/17	12/16/17	0.01	0.29	Brake NC 2		SB DAS 9-86
140	QC	20 pcs	12/16/17	12/16/17	0.00	0.00	QC5		38
150	HandFinish	20 pcs	12/16/17	12/16/17	0.00	0.22	HandFinish1		BEP 17/12/17
160	QC	20 pcs	12/16/17	12/16/17	0.00	0.00	QC7		DR 17-12-17
170	Powdercoat	20 pcs	12/18/17	12/18/17	0.00	0.23	Powdercoat11		DR 17-12-17
180	QC	20 pcs	12/18/17	12/18/17	0.00	0.00	QC3		PD 17/12/17
190	Packaging	20 pcs	12/18/17	12/18/17	0.00	0.00	Packaging3	57 128	DE 20 2017
200	QC21-SA	20 Ea	12/18/17	12/18/17	0.00	0.00	QC21		DEC 20 2017

Part Op 100 - 1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr as required
Descriptions: 170 - START TIME: 1:30 OVEN TEMPERATURE: 320° FINISH TIME: 2:00 - 11/22/17

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.063 <u>137599</u>	0	389	0	0

Part Specifications

Specifications could not be found.

Plex 12/14/17 6:55 AM dart.lacelle.linda

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By		
								Lead hand / Supervisor Approval Verification		
								Coordinator Approval		
								Revision: _____		
								Operation: _____		
								Change No: _____		
								PART NO: _____		
								ned Wrong		
								e Dimensions		
								nder tolerance		
								correct		
								ist/Missing		
								oved		
								g		
								id		
								g Sequence		

Job No: 168432-A
Mfg Date: 12/14/17

Start up Operation

D4935-1

Mounting Bracket

S021874

DART AEROSPACE

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Root Cause		
Environment	☐	No Re-verification
Design	☐	Operator
Doc/Data	☐	Offset/Setup
Equip/Tooling	☐	Supplier
Handling/Pre	☐	Training
Material	☐	Use for Testing
Internal Transport	☐	Poor Information
Tribal Knowledge	☐	Rushing
LOA	☐	Product Improvement
Substation	☐	Process Improvement
Past Expiry Date	☐	Manufacturing Process
Misidentified	☐	Past Due
		OTHER : _____

DQA: _____ Date: _____



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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

8

7

6

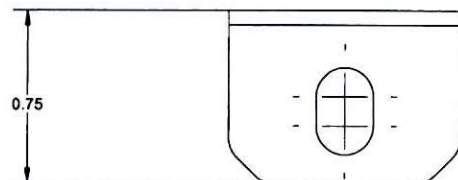
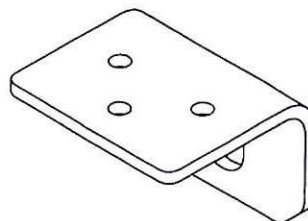
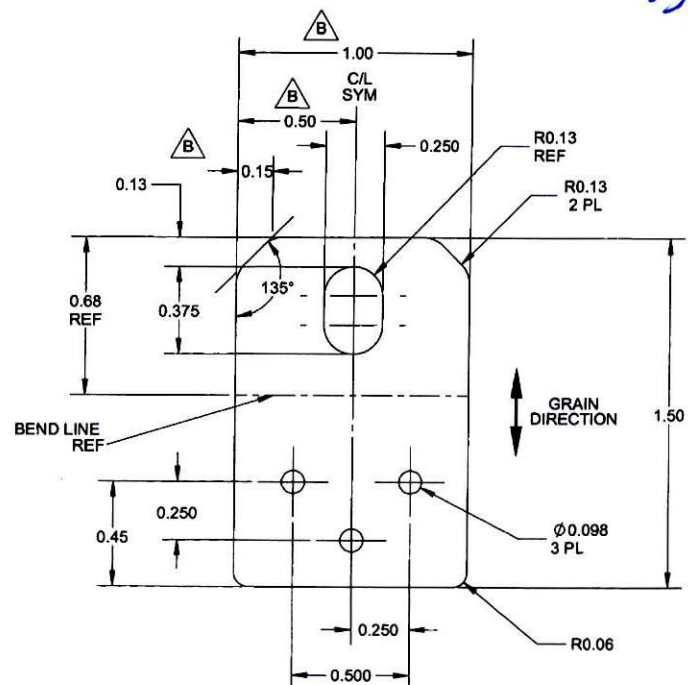
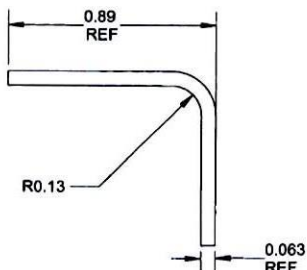
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168432-1

**D4935-1 EAPS MOUNTING BRACKET****D4935-1F FLAT PATTERN**

RELEASED
 2014-06-16
MD

NOTES:

- 1) MATERIAL: D4935-1: MAKE FROM D4935-1F
 D4935-1F: 6061-T6/T62 ALUMINUM SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11
 OR AMS 4025 OR AMS 4027 OR ASTM B209, REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "BLACK GLOSS" (4.3.5.13) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 LBS

APPROVED

B	ADD 0.15 X 45° CHAMFER, 2 PL, 1.00 WAS 1.09	DB	14.01.16
A	NEW ISSUE	DB	13.10.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4935 TITLE EAPS MOUNTING BRACKET SCALE NTS	
DRAWN	DB		
CHECKED	AP		
MFG. APPR.	DD		
APPROVED	MP		
DE APPR.	DS	DATE 14.01.16 COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPLICIT CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



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